Work Order ID 105558 *105558*

August-08-13 8:58:44 AM

D2565-105
B105558

Item ID:	D2565-105	**Accept**	*N900040100*
Revision ID:			
Item Name:	Strut		
Start Date:	8/08/13	**Start Qty:** 5.00	*5*
Required Date:	8/08/13	**Req'd Qty:** 5.00	*5*
Reference:			

Setup Start *NS1* Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1* Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 13-08-08 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Brake NC	NC BRAKE	0.00				5			80 13/10/10
Brake NC	**Memo** Punch as per Dwg D2565 usingDT 8313	0.00							
110 *110* Small Fab	Small Fab	0.00				5		88	13-10-23
Small Fab	**Memo** Drill hole open to .316 Ø as per Dwg D2565 (one end only) Deburr	0.00							
120 *120* QC	QC5- Inspect part completeness to step on W/O	0.00	DAS 27 9-89 13-10-23			S			
Quality Control	**Memo**	0.00							

Draw Nbr	Revision Nbr
D2565	Rev E

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Item ID:	D2565-105		**Accept**	*N900040100*	**Setup Start** *NS1*
Revision ID:					**Stop** *NS2*
Item Name:	Strut				
Start Date:	8/08/13	**Start Qty:** 5.00	*5*	**Cust Item ID:**	
Required Date:	8/08/13	**Req'd Qty:** 5.00	*5*	**Customer:**	
Reference:					

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________
QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M126125	0.00				5	0	13-10-24	DAS 34 9-89
	Memo START TIME: 2:45 OVEN TEMPERATURE: 400° FINISH TIME: 315	0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish	0.00	DAS 27 9-89			5			
	Memo	0.00	131023						
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: 5T252	0.00				5			DAS 33 9-89 131025
	Memo	0.00							

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ________	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
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☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 105558 *105558*

August-08-13 8:58:44 AM

Item ID: D2565-105 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Strut **Stop** *NS2*

Start Date: 8/08/13 **Start Qty:** 5.00 *5* **Cust Item ID:**

Required Date: 8/08/13 **Req'd Qty:** 5.00 *5* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					Rm 13/10/29.		HB

MF 13-10-28

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
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☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

August-08-13 8:58:44 AM

Work Order ID: **105558**

Parent Item: **D2565-105**

Parent Item Name: Strut

Start Date: 8/08/13 **Required Date:** 8/08/13

Start Qty: 5.00 **Required Qty:** 5.00

Comments: IPP: F02.04.16Added dwg Rev.C1NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 304 RD Tube .750 x .049W		Purchased	No			100	f	586.5189	**1.6825**	**8.855263**	8	13/6/10	

Location	Loc Qty	Loc Code
MAT017	586.5188835	
122312	13.3	
122468	0.0000325	
124768	56.63245	
125068	4.5664	
125513	9.9	
M126183	342.120001	
M126349	160	11

DQA: ________ Date: ______________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ________________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ________________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
NCR No. ________________	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
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☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

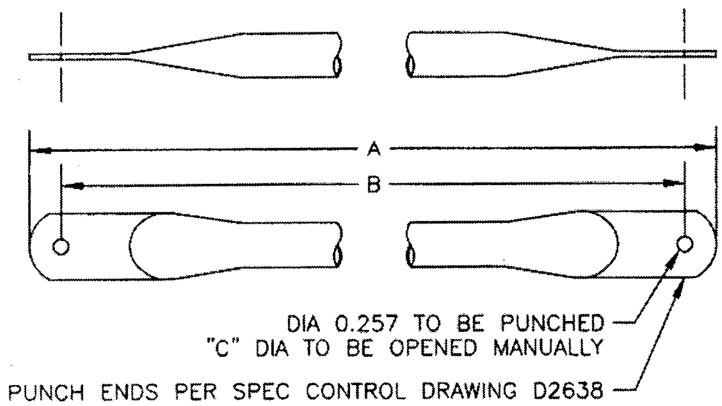
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3

QA COPY ISSUED

RELEASED 04.05.05

REV	DATE	DESCRIPTION
A	96.05.03	NEW ISSUE
B	97.03.15	CORRECT D2565-111 DIM. A
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD

Description: Strut		Work Order: 105558
Inspection Drawing: D2568	Rev: E	Part Number: D2565-105

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
20.19	+/- .030	20.19	✓		T	SB-5
19.39	+/- .030	19.39	✓		T	SB-5
Ø .316	+/- .005	Ø .316	✓		Calp.	8 Feb-14
Ø .257	+/- .005	Ø .257	✓		V	5 Feb 14

Measured by: SB	Checked By: [signature]	QC inspector: DAS 27 9-89	Engineering Approval (*if necessary*):
Date 13/10/10	Date 13-10-23	Date 13 10 23	Date

H:\FORMS\Quality Assurance\approved QA\Inspection sheet revA